



US009343944B2

(12) **United States Patent**
Kishi et al.

(10) **Patent No.:** **US 9,343,944 B2**
(45) **Date of Patent:** **May 17, 2016**

(54) **STATOR FOR ELECTRIC ROTARY MACHINE**

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(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 302 days.

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(21) Appl. No.: **13/553,445**

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(22) Filed: **Jul. 19, 2012**

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(65) **Prior Publication Data**

US 2013/0020901 A1 Jan. 24, 2013

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(30) **Foreign Application Priority Data**

(Continued)

Jul. 21, 2011 (JP) 2011-160220

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(51) **Int. Cl.**

H02K 3/34 (2006.01)

H02K 9/22 (2006.01)

H02K 3/12 (2006.01)

H02K 3/24 (2006.01)

H02K 15/00 (2006.01)

(52) **U.S. Cl.**

CPC .. **H02K 9/22** (2013.01); **H02K 3/12** (2013.01);
H02K 3/345 (2013.01); **H02K 15/0081**
(2013.01); **H02K 3/24** (2013.01); **H02K 3/34**
(2013.01); **H02K 15/0025** (2013.01)

(58) **Field of Classification Search**

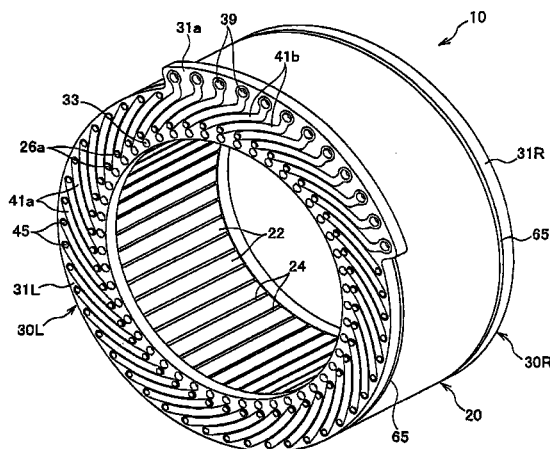
CPC H02K 15/0025; H02K 3/24; H02K 3/34
USPC 310/DIG. 6, 71, 201, 215, 179, 180;
29/605

See application file for complete search history.

(57) **ABSTRACT**

A stator for an electric rotary machine includes: a stator core having a plurality of slots; and segmented coils of a plurality of phases, wherein: the segmented coils of a plurality of phases have pluralities of coil bars which are inserted individually in the plurality of slots in the stator core and which extend substantially in a straight line and pluralities of connection coils which connect together the coil bars of the same phase to thereby make up extending portions; and the coil bars are fixed in place individually in the slots in the stator core in such a state that the coil bars each are covered by an insulation material.

6 Claims, 16 Drawing Sheets



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FIG. 1

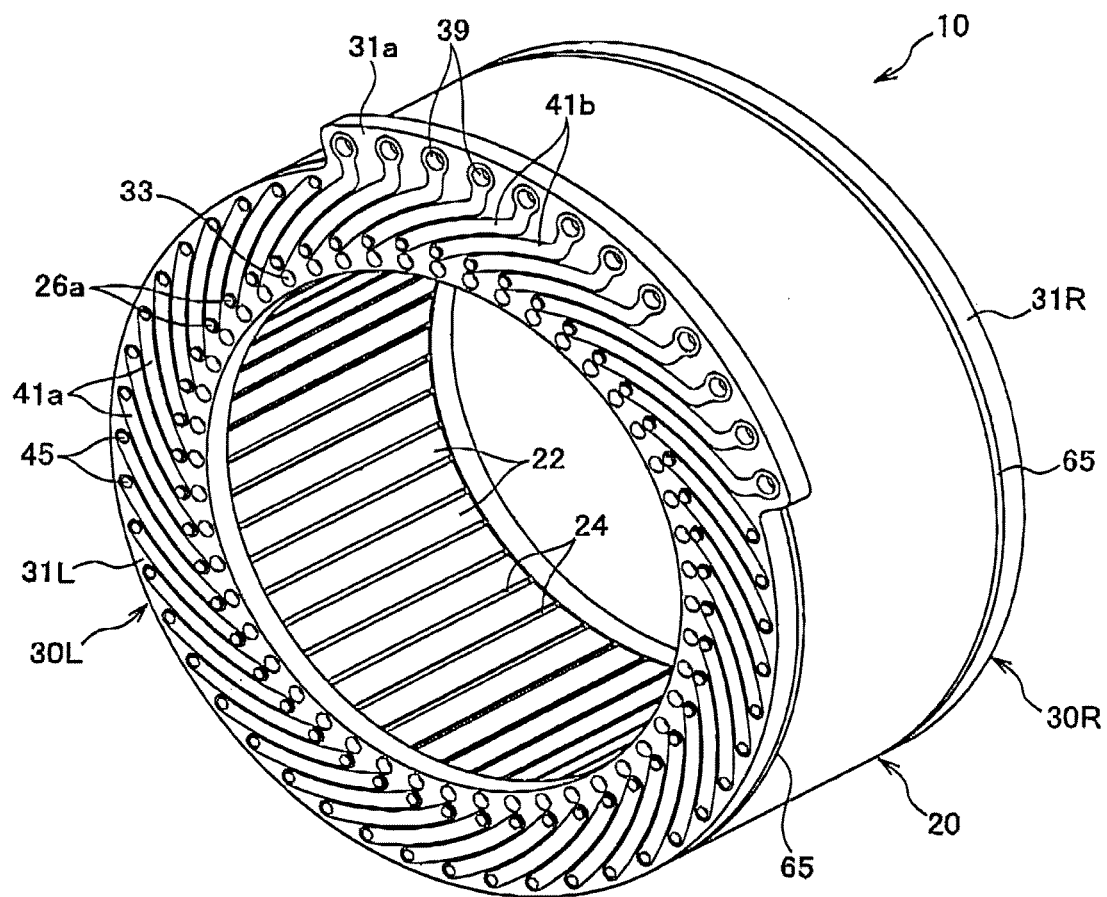


FIG. 2

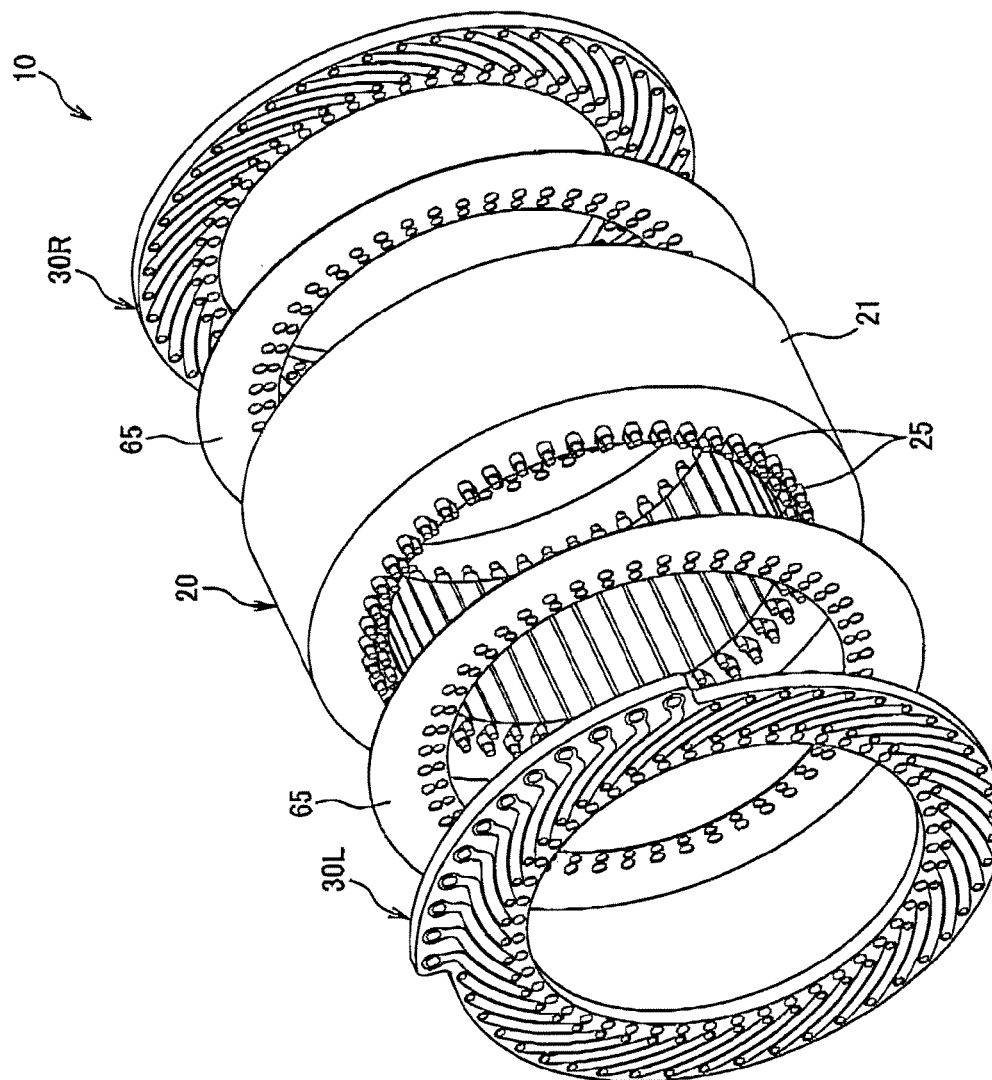


FIG. 3A

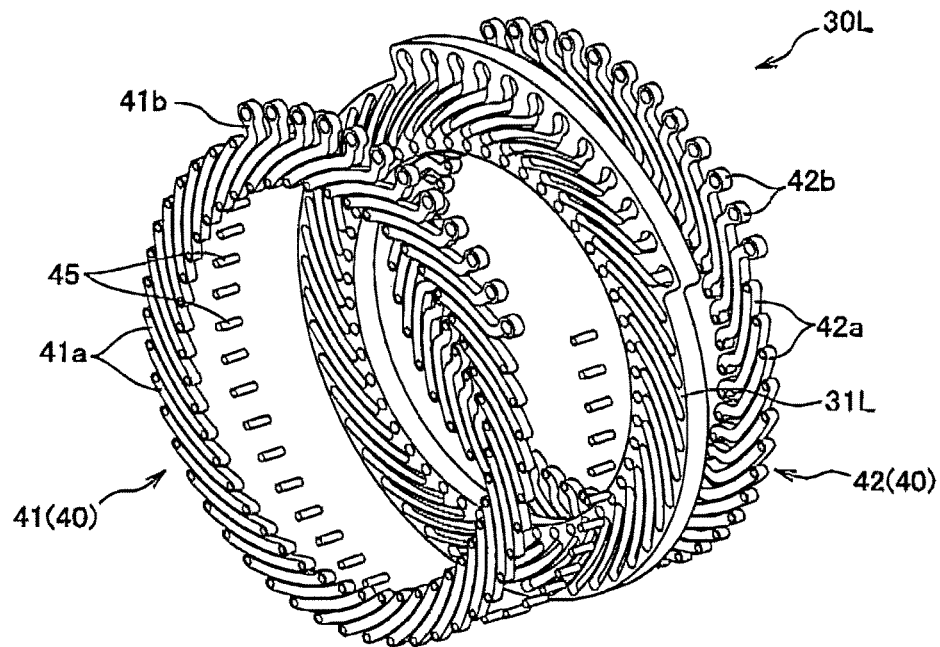


FIG. 3B

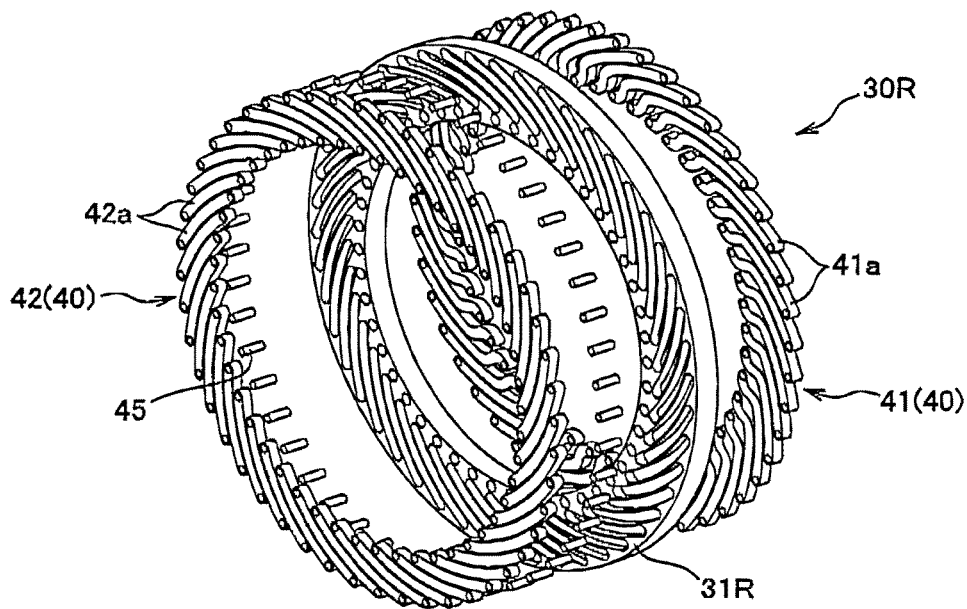


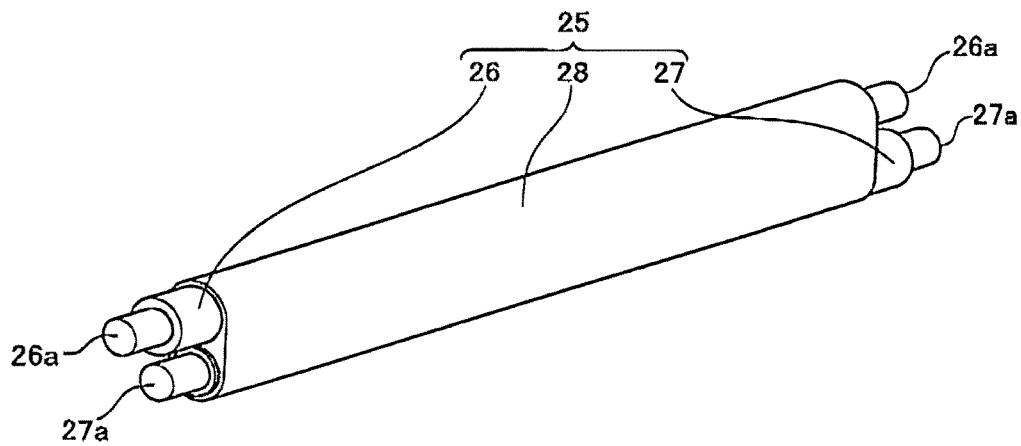
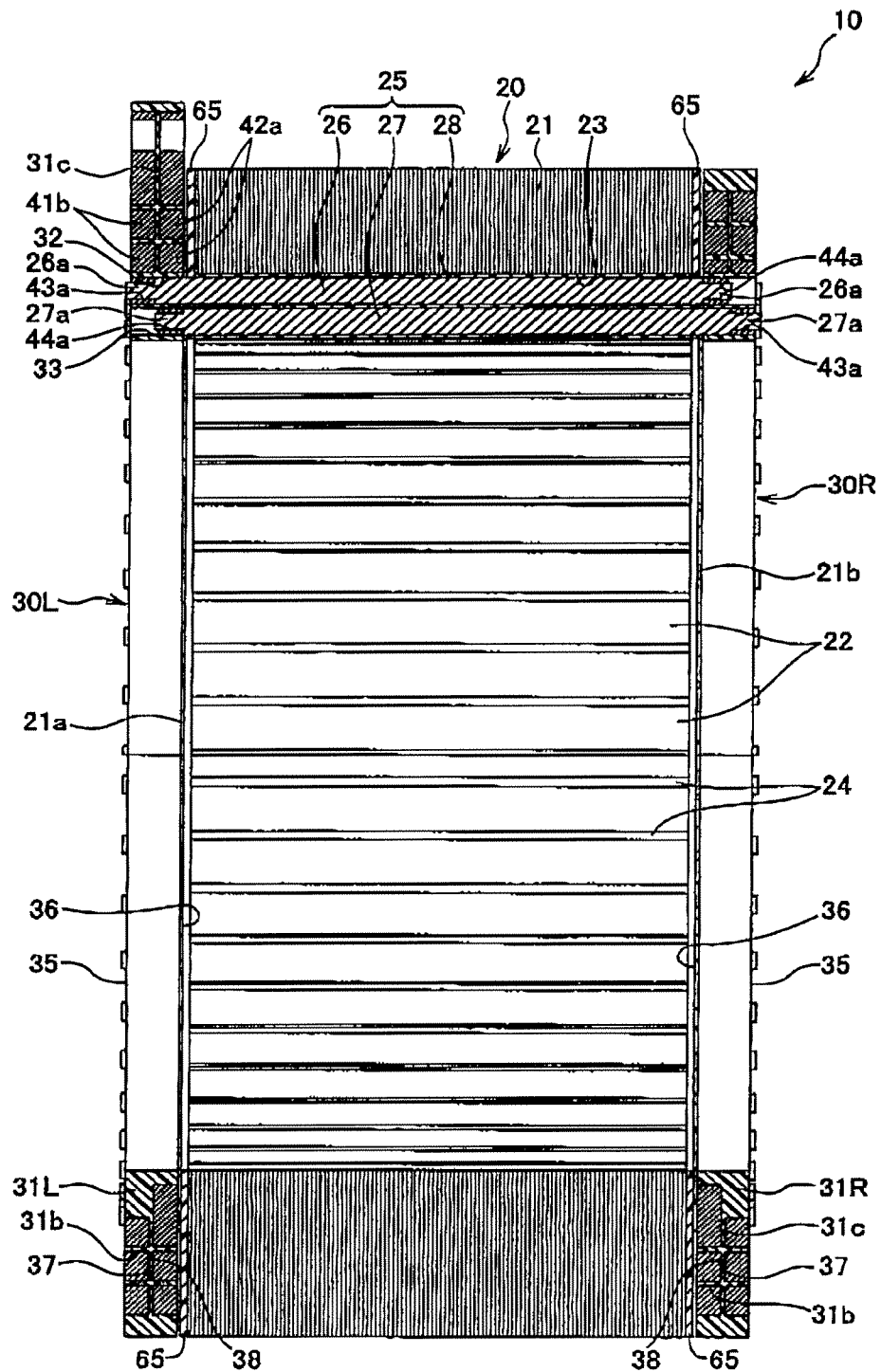
FIG. 4

FIG. 5



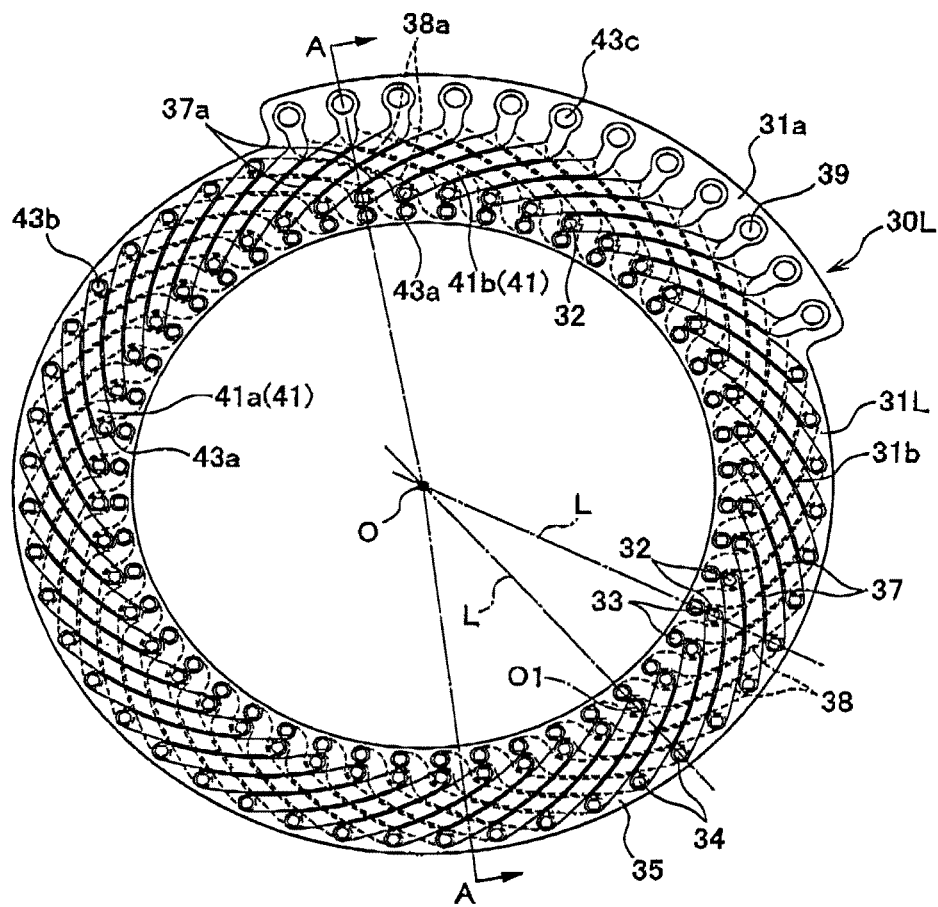


FIG. 7

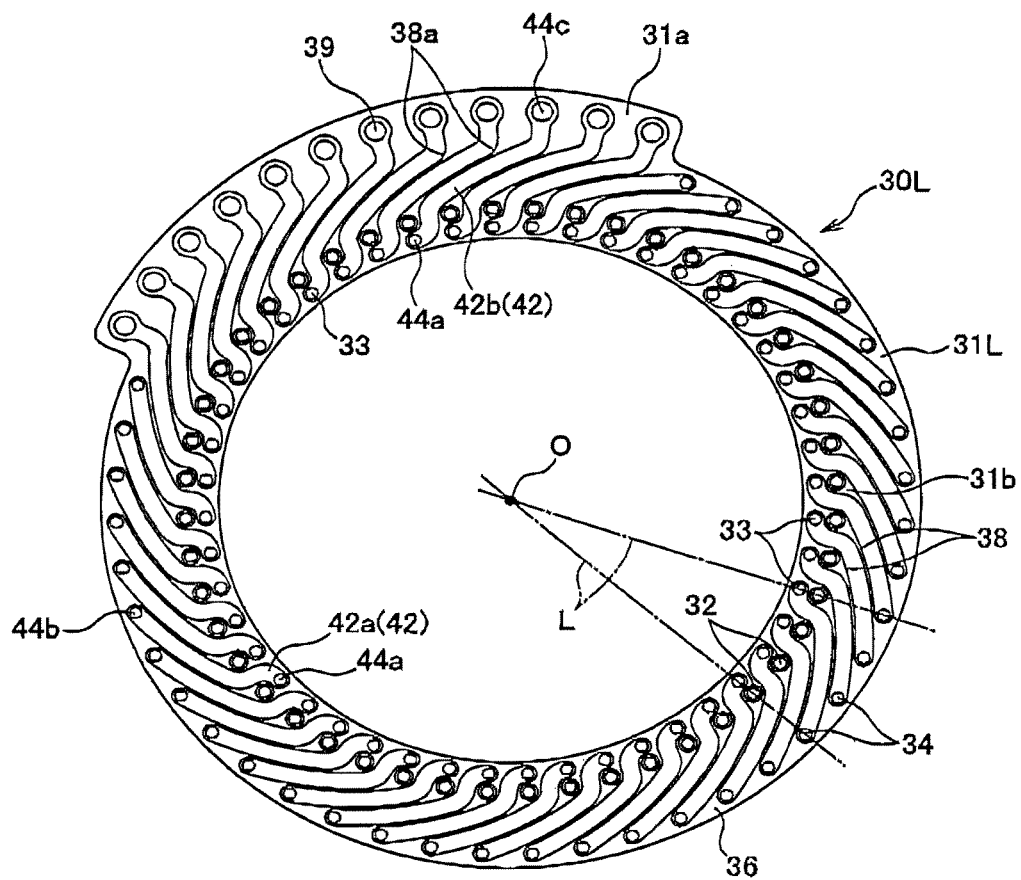


FIG. 8

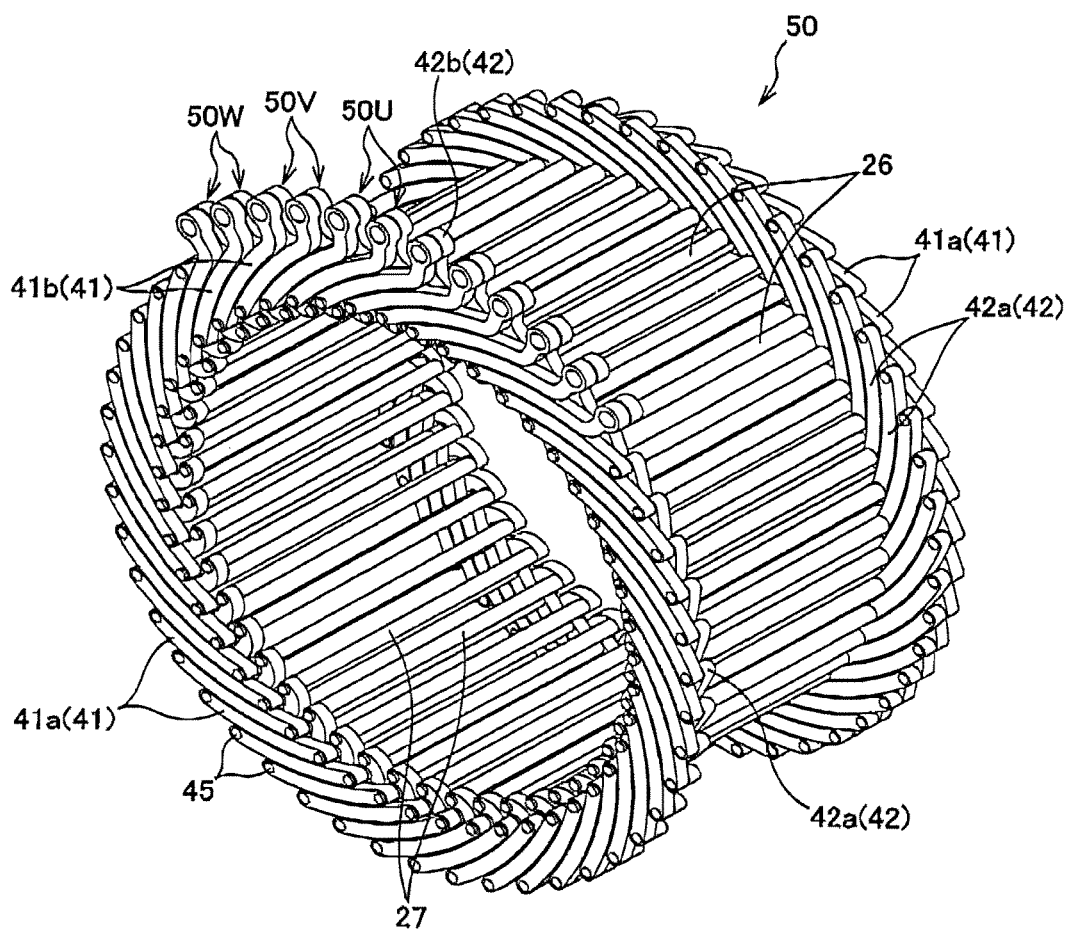


FIG. 9

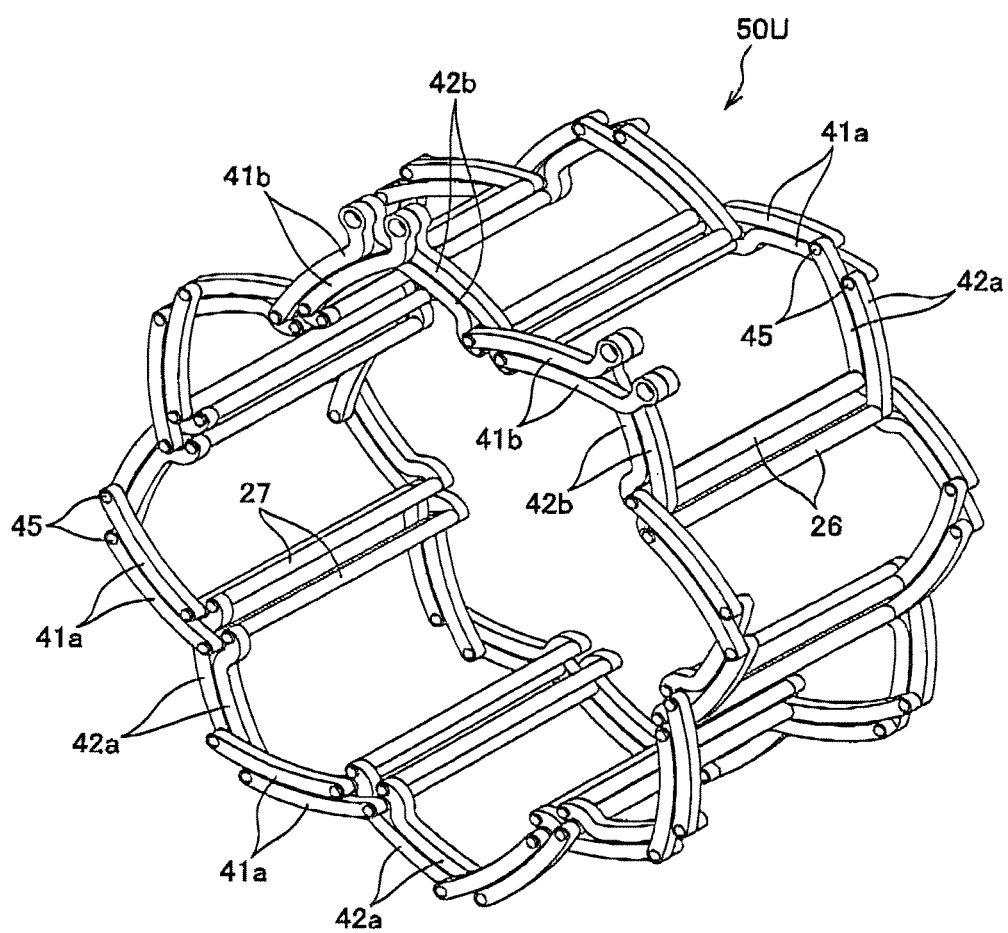


FIG. 10

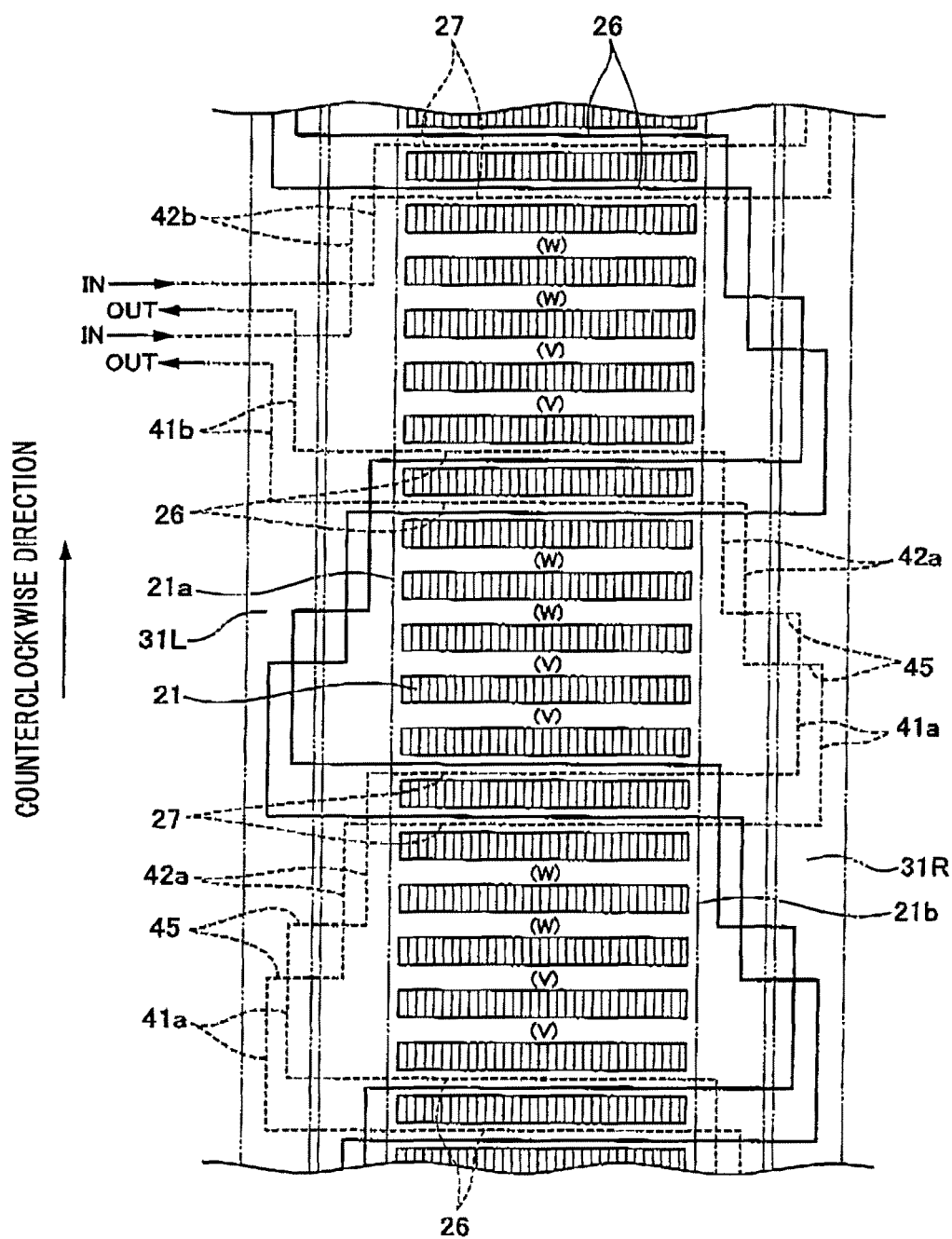


FIG. 11A

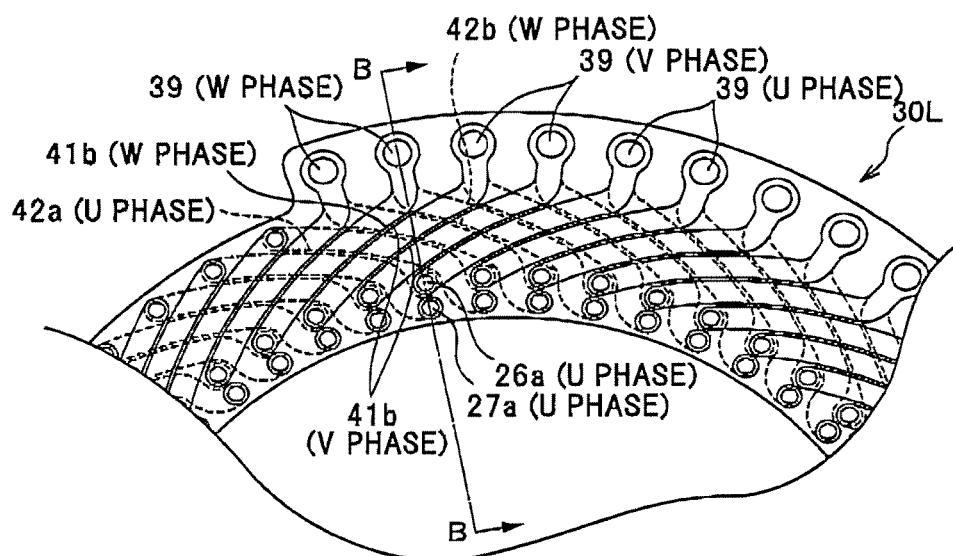


FIG. 11B

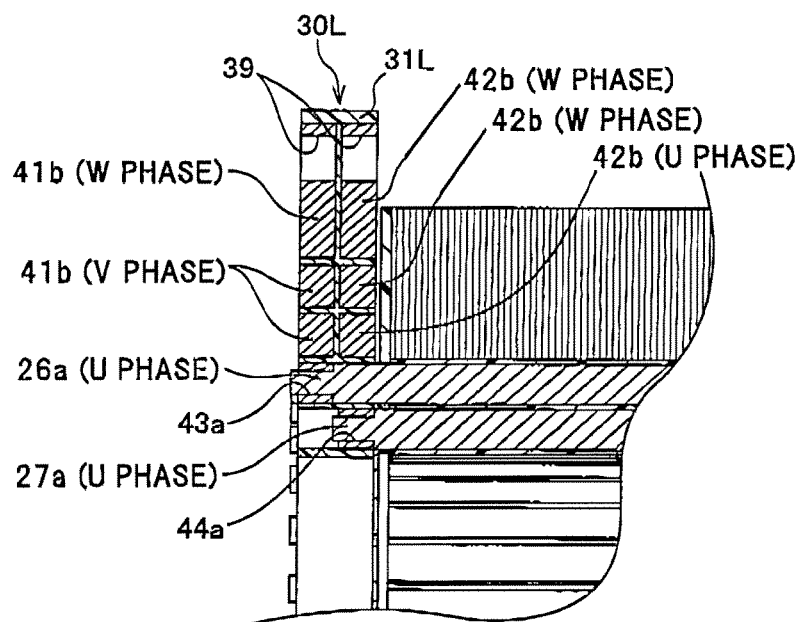


FIG. 12A

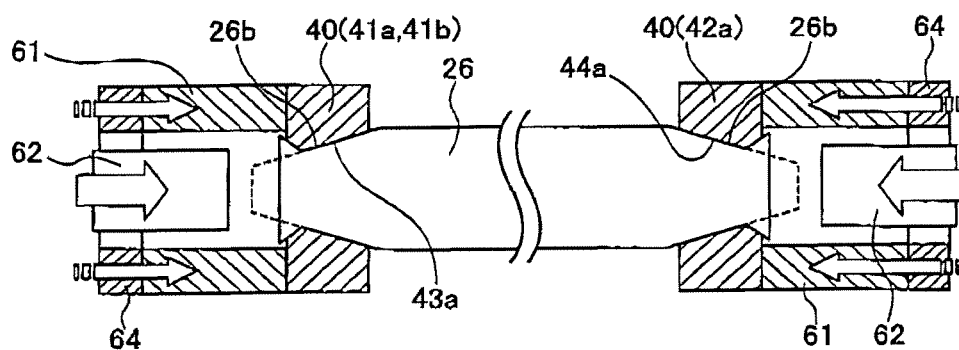


FIG. 12B

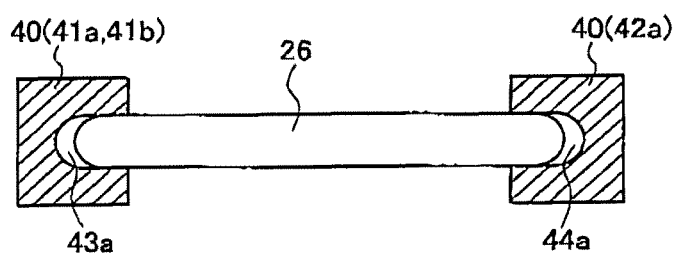


FIG 12C

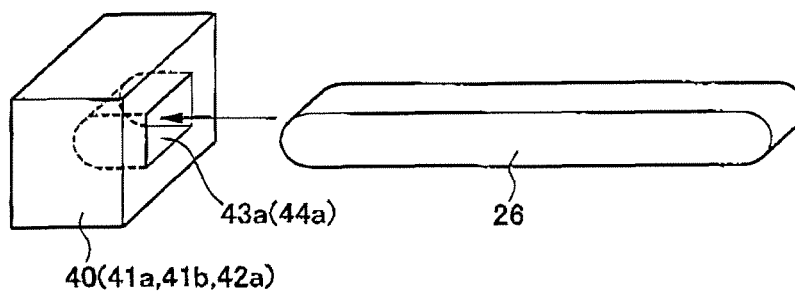


FIG. 13

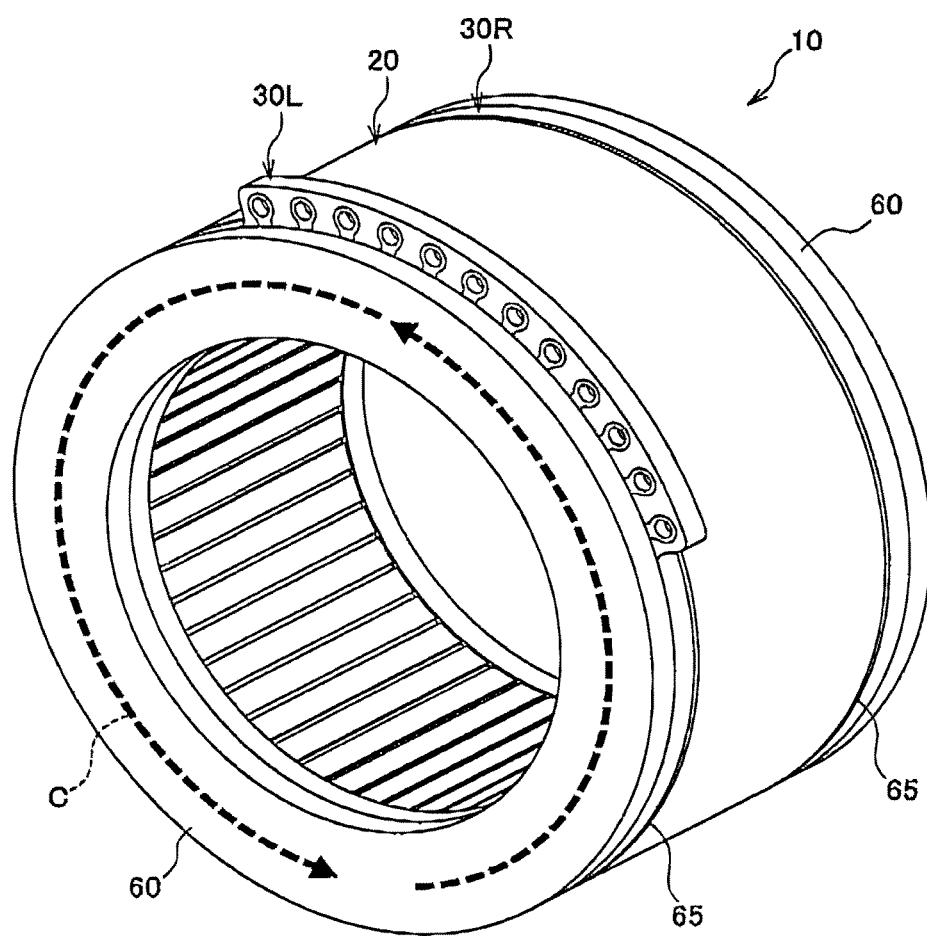


FIG. 14

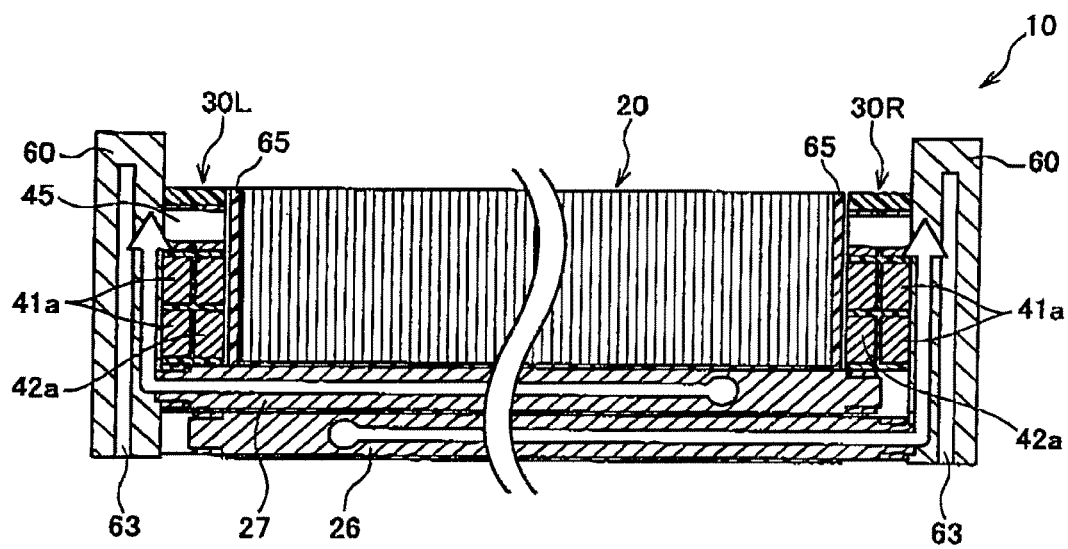


FIG. 15

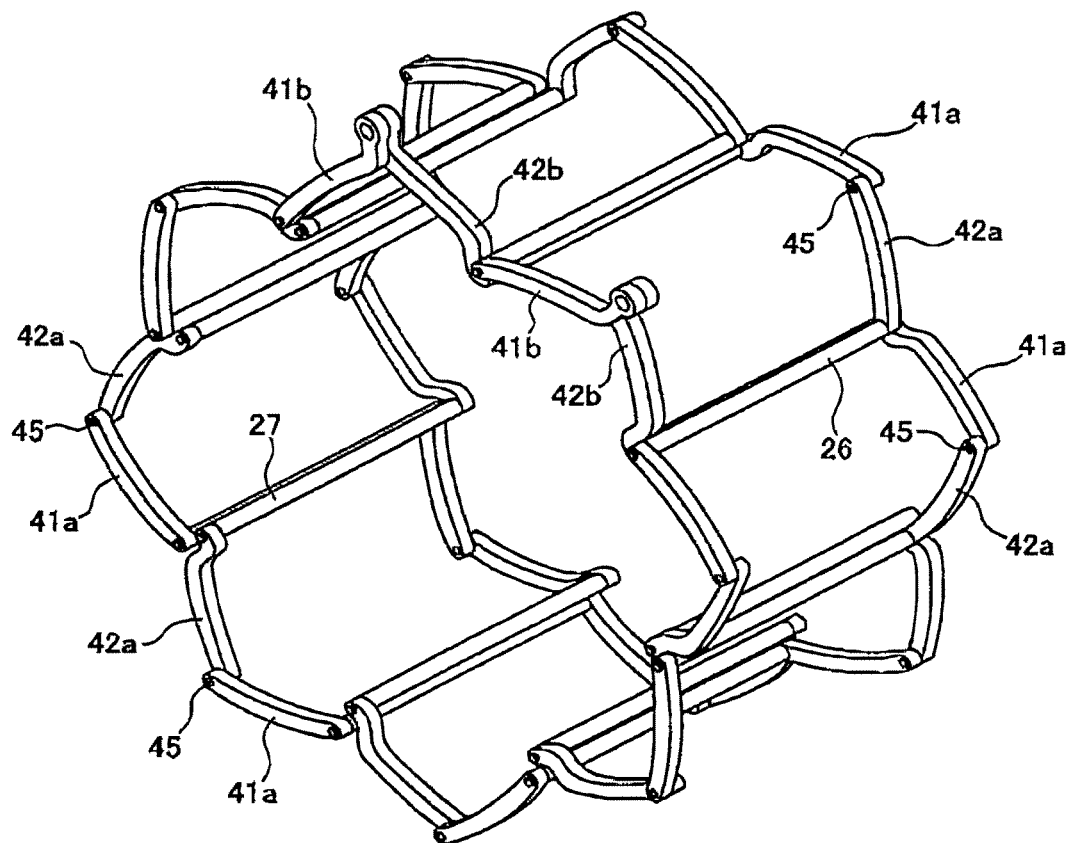
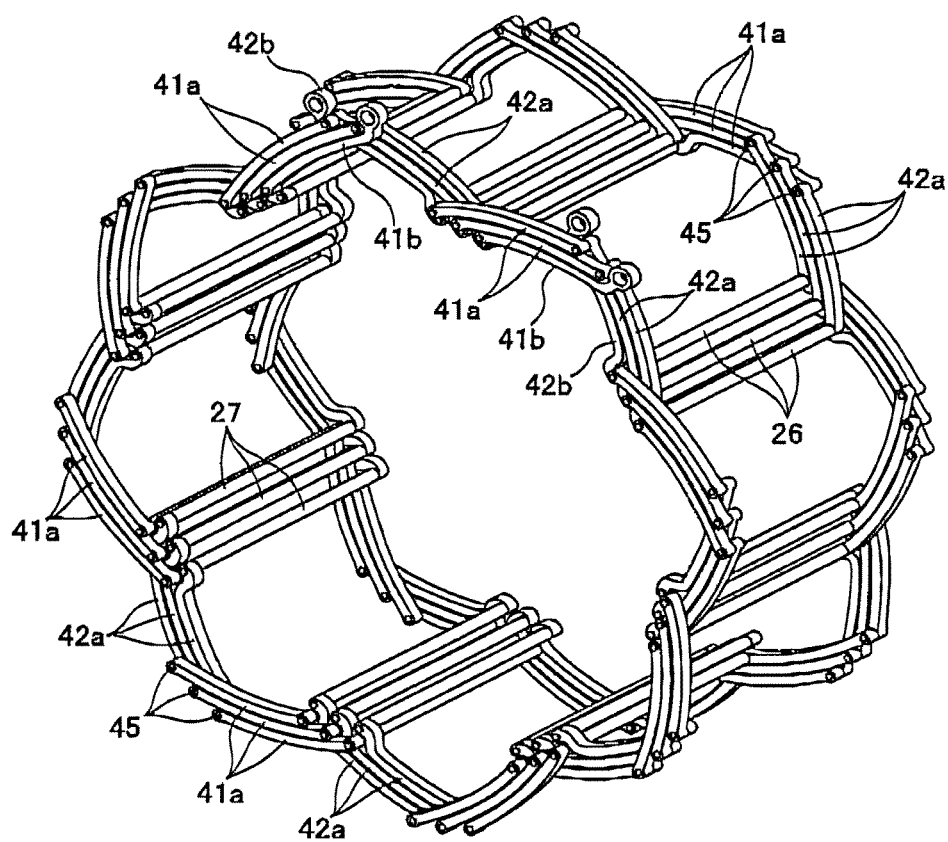


FIG. 16



1

STATOR FOR ELECTRIC ROTARY MACHINE**BACKGROUND****1. Field of the Invention**

The present invention relates to a stator for an electric rotary machine which is installed in an electric vehicle or a hybrid vehicle and a fabrication method of the same stator.

2. Description of the Related Art

Conventionally, there has been known a type of stators for electric rotary machines in which coils are fabricated by winding windings around teeth of a stator core. In addition, as another type of stators for electric rotary machines, there have also been known stators in which coils are formed by inserting plural segments each made up of an electric conductor which is formed into a U-shape using segment coils in slots in a stator core, and thereafter bending leg portions and connecting end portions of the segments (refer to JP-A-2003-158840 and U.S. Pat. No. 6,894,417).

However, in such conventional electric rotary machines in which coils are fabricated by winding windings around teeth of a stator core, the windings and the stator core need to be handled separately. In addition, the winding operation becomes complex and troublesome since the windings are wound while inserting insulation papers so as to be held between the windings so wound, and there are caused fears that the insulation paper is caught between the winding wound, whereby a proper insulating performance cannot be ensured.

In addition, in the stators for electric rotary machines for vehicles described in JP-A-2003-158840 and U.S. Pat. No. 6,894,417, coils are formed through a forming operation of forming electric conductors into a U-shape, a bending operation of bending leg portions and a joining (welding) operation of joining together end portions of the electric conductors. Consequently, until the coils are formed through the joining operation, the stator core and the plural U-shaped electric conductors need to be handled separately. Further, since the U-shaped electric conductor is inserted in the slot after the insulation paper is inserted therein, there are caused fears that the electric conductor comes into contact with the insulation paper when the electric conductor is so inserted, and the insulation paper is caught between the electric conductor and the slot, whereby a proper insulating performance cannot be ensured.

SUMMARY

The invention has been made in view of the problems described above, and an object thereof is to provide a stator for an electric rotary machine which is superior in handling properties of a stator core and coils and insulation properties.

With a view to attaining the object, according to a first aspect of the invention, there is provided a stator (for example, a stator **10** in an embodiment which will be described later) for an electric rotary machine including:

a stator core (for example, a stator core **21** in the embodiment) having plural slots (for example, slots **23** in the embodiment); and

segmented coils of plural phases (for example, coils **50** in the embodiment), wherein

the segmented coils of plural phases have plural coil bars (for example, coil bars **25** in the embodiment) which are inserted individually in the plural slots in the stator core and which extend substantially in a straight line and plural connection coils (for example, connection coils **40** in the embodi-

2

ment) which connect together the coil bars of the same phase to thereby make up extending portions, and wherein

the coil bars are fixed in place individually in the slots in the stator core in such a state that the coil bars each are covered by an insulation material (for example, an insulation material **28** in the embodiment).

According to a second aspect of the invention, there is provided a stator core for an electric rotary machine as set forth in the first aspect, wherein

the coil bars of the same phase are inserted in the slot, and the insulation material combines the coil bars in the slot so as to become a whole.

According to a third aspect of the invention, there is provided a stator core for an electric rotary machine as set forth in the first or second aspect, wherein

the coil bars which are inserted together in the slot have the same length and are configured as a radially outer coil bar (for example, a radially outer coil bar **26** in the embodiment) and a radially inner coil bar (for example, a radially inner coil bar **27** in the embodiment) which are aligned in a radial direction, and wherein

the radially outer coil bar and the radially inner coil bar are covered by the insulation material in such a state that the radially outer and inner coil bars are offset from each other in an axial direction so that end portions thereof take different axial positions.

According to a fourth aspect of the invention, there is provided a stator core for an electric rotary machine as set forth in the third aspect, wherein

the radially outer coil bar and the radially inner coil bar which are covered together by the insulation material are press fitted in the slot in the stator core.

According to the first aspect of the invention, the stator core, the coil bars and the insulation materials are unitized since the coil bars are fixed in place individually in the slots in such a state that the coil bars each are covered by the insulation material, whereby not only are the handling properties enhanced, but also the insulation performance is enhanced. In addition, the coils of plural phases can easily be fabricated by inserting the coil bars each covered by the insulation material individually in the slots in the stator.

According to the second aspect of the invention, the handling properties are improved, and the plural coil bars as a whole can easily be inserted in the slot.

According to the third aspect of the invention, the coil bars can be connected together in accordance with the axial positions of the connection coils, and parts for the radially outer coil bar and the radially inner coil bar can be commonized.

According to the fourth aspect of the invention, the radially outer coil bar and the radially inner coil bar which are covered together by the insulation material can be fixed in place in the slot in the stator core easily and in an ensured fashion.

BRIEF DESCRIPTION OF THE DRAWINGS

The present invention will become more fully understood from the detailed description given hereinafter and the accompanying drawing which is given by way of illustration only, and thus is not limitative of the present invention and wherein:

FIG. **1** is a perspective view of a stator for an electric rotary machine according to the invention;

FIG. **2** is an exploded perspective view of the stator shown in FIG. **1**;

FIG. **3A** is an exploded perspective view of one of base plate assemblies shown in FIG. **2**, and FIG. **3B** is an exploded perspective view of the other base plate assembly;

3

FIG. 4 is a perspective view of a coil bar;

FIG. 5 is a vertical sectional view of the stator shown in FIG. 1 which is taken along the line A-A in FIG. 6;

FIG. 6 is a front view of the one base plate assembly shown in FIG. 3A;

FIG. 7 is a rear view of the one base plate assembly shown in FIG. 3A;

FIG. 8 is a perspective view of double-slot type, segmented coils of plural phases;

FIG. 9 is a perspective view of coils of one phase which are taken out from the coils of the plural phases shown in FIG. 8;

FIG. 10 is an exemplary diagram showing the configuration of the coils of the plural phases;

FIG. 11A is a partial enlarged view of FIG. 6, and FIG. 11B is a sectional view taken along the line B-B in FIG. 11A;

FIG. 12A is an exemplary diagram showing a state in which a coil bar and connection coils are connected together through crimping, FIG. 12B is an exemplary diagram showing a state in which a coil bar having semi-spherical end portions is connected to connection coils through press fitting, and FIG. 12C is an exemplary diagram showing a state in which a coil bar having semi-circular end portions and a rectangular cross section is connected to connection coils by being press fitted in holes in the connection coils;

FIG. 13 is a perspective view of the stator in which cooling plates are disposed on end faces of the base plate assemblies;

FIG. 14 is a vertical sectional view of a main part of the stator including the cooling plates shown in FIG. 13;

FIG. 15 is a perspective view of coils of one phase making up single-slot type coils of plural phases; and

FIG. 16 is a perspective view of coils of one phase making up triple-slot type coils of plural phases.

DETAILED DESCRIPTION OF THE INVENTION

Hereinafter, an embodiment of the invention will be described by reference to the accompanying drawings. The drawings are to be seen in an orientation in which reference numerals given look properly.

As shown in FIGS. 1, 2 and 5, a stator 10 for an electric rotary machine according to this embodiment includes a stator core assembly 20 and a pair of base plate assemblies 30L, 30R, and the base plate assemblies 30L, 30R are disposed and assembled individually to ends of the stator core assembly 20. An insulation sheet 65 which is made of, for example, silicone is disposed between the stator core assembly 20 and each of the base plate assemblies 30L, 30R.

The stator core assembly 20 includes a stator core 21 and plural (48 in the embodiment shown in the figures) coil bars 25.

The stator core 21 is made up, for example, of plural silicon steel sheets which are blanked out by a blanking press and are laminated together and includes 48 teeth provided on a radially inner side thereof and 48 slots 23 which are formed between the teeth 22, 22 which lie adjacent to each other. The slots 23 are formed so as to penetrate the stator core 21 in an axial direction thereof and have a substantially elliptic shape which is elongated in a radial direction of the stator core 21 when viewed from the axial direction thereof. The slots 23 also have opening portions 24 which are opened to an inner circumferential surface of the stator core 21.

Also referring to FIG. 4, the coil bar 25 includes a radially outer coil bar 26 and a radially inner coil bar 27 which have the same shape and length. The radially outer coil bar 26 and the radially inner coil bar 27 are disposed parallel while being offset from each other in the axial direction by such an extent as a thickness of a connection coil 40, which will be described

4

later. The radially outer coil bar 26 and the radially inner coil bar 27 are formed integrally by being covered on the periphery thereof by an insulation material 28 which is injection molded from a resin, with both ends of each coil bar left uncovered. Specifically, the length of each of the radially outer coil bar 26 and the radially inner coil bar 27 is set to a length which is substantially equal to a sum of an axial length of the stator core 21 and a thickness of three connection coils 40, and small-diameter portions 26a, 27a are formed at both the ends of the radially outer coil bar 26 and the radially inner coil bar 27, respectively, the length of the small-diameter portions 26a, 27b being substantially equal to the thickness of the connection coil 40.

The plural (48 in the embodiment shown in the figures) coil bars 25, each made up of the radially outer coil bar 26 and the radially inner coil bar 27, are, as shown in FIG. 5, aligned in a radial direction of the stator core 21 so that the radially outer coil bar 26 is situated radially outwards and are inserted individually in the 48 slots 23 in the stator core 21 to thereby be aligned in a circumferential direction of the stator core 21. Thus, the plural coil bars 25 make up the stator core assembly 20.

The radially outer coil bars 26 are inserted individually in the slots 23 so that the small-diameter portion 26a projects approximately by such an extent as a thickness of two connection coils 40 from one end face 21a (a left end face in FIG. 5) of the stator core 21, while the small-diameter portion 26a projects approximately by such an extent as the thickness of the connection coil 40 from the other end face 21b (a right end face in FIG. 5).

Additionally, the radially inner coil bars 27 are inserted individually in the slots 23 so that the small-diameter portion 27a projects approximately by such an extent as the thickness of the connection coil 40 from the one end face 21a of the stator core 21, while the small-diameter portion 27a projects approximately by such an extent as the thickness of two connection coils 40 from the other end face 21b. The insulation material 28 that covers both coil bars 26 and 27 is interposed between the radially outer coil bar 26 and the radially inner coil bar 27 and the slot 23 in the stator core 21 so as to ensure the insulation between the radially outer and inner coil bars 26, 27 and the stator core 21. Consequently, the radially outer coil bar 26 and the radially inner coil bar 27 are covered by the insulation member 28 in such a state that the radially outer and inner coil bars 26, 27 are offset from each other in the axial direction so that the axial positions of the end portions thereof differ from each other.

The insulation material 28 which covers the radially outer coil bar 26 and the radially inner coil bar 27 has substantially the same shape as that of the slot 23 and is sized slightly larger than the slot 23. Thus, the insulation material 28 can easily be press fitted in the slot 23 so as to be fixed in place therein. In addition, the radially outer coil bar 26 and the radially inner coil bar 27 are thicker than a conventional coil which is made up of a winding which is wound therearound, and hence, there is provided an advantage that the space factor relative to the slot 23 is increased.

As shown in FIGS. 1 to 7, the base plate assemblies 30L, 30R which are disposed individually at the ends of the stator core assembly 20 include base plates 31L, 31R and plural connection coils 40. The base plate assembly 30R differs from the base plate assembly 30L in that the former does not include a connecting terminal portion, which will be described later, and in that the shapes of grooves formed and the connection coils provided on the former differ from those of the latter. The other configurations of both the base plate

5

assemblies are the same, and therefore, the base plate assembly 30L will mainly be described hereinafter.

As shown in FIGS. 6 and 7, the base plate 31L is formed from a resin (a non-magnetic material) having insulating properties and is a substantially annular member having substantially the same inside and outside diameters as those of the stator core 21. A deployment portion 31a is provided at an upper portion of the base plate 31L as seen in the figures so as to extend radially outwards therefrom into the shape of a segment. A connecting terminal portion is formed on the deployment portion 31a for connection to external equipment or the like.

48 pairs of radially outer through holes 32 and radially inner through holes 33 are formed to penetrate the base plate 31L at a radially inner side of the base plate 31L so as to correspond, respectively, to the radially outer coil bars 26 and the radially inner coil bars 27 of the coil bars 25 which are inserted in the slots 23 in the stator core 21.

The radially outer through hole 32 and the radially inner through hole 33 which make a pair are situated on the same straight line L which extends from a center O of the base plate 31 in a radial direction. Further, a radially outermost hole 34 is formed on an outside diameter side of the base plate 31L. Thus, the radially outer and inner through holes 32, 33 and radially outermost hole 34 establish a communication between an outer surface 35 and an inner surface 36 of the base plate 31L (refer to FIG. 5). Additionally, in a circumferential position where the deployment portion 31a is formed, 12 connecting terminal joining holes 39 are formed which are situated further radially outwards than the position of the radially outermost hole 34 in the deployment portion 31a.

As shown in FIGS. 5 to 7, plural (48) outer surface grooves 37 and inner surface grooves 38 are formed along involute curves so as to lie close to one another on the outer surface 35 and the inner surface 36 of the base plate 31L, respectively. The outer surface grooves 37 and the inner surface grooves 38 are formed to have a U-shaped section which is opened to the outer surface 35 and the inner surface 36, respectively. The adjacent outer surface grooves 37 and the adjacent inner surface grooves 38 are isolated by walls 31b which is erected from the base plate 31L, and the outer surface grooves 37 and the inner surface grooves 38 which face each other in an axial direction are isolated by a bulkhead 31c, whereby the outer surface grooves 37 and the inner surface grooves 38 are electrically insulated one by one.

In addition, the base plate 31 is given an axial width which is substantially equal to a sum of groove depths of the outer surface groove 37 and the inner surface groove 38 which correspond, respectively, to an outer connection coil 41 and an inner connection coil 42, which will both be described later, and a thickness of the bulkhead 31c.

In the base plate assembly 30L, as shown in a front view of the base plate in FIG. 6, each outer surface groove 37 on the base plate 31L is formed in a curved fashion along the involute curve so as to connect one radially outer through hole 32 with one radially outermost hole 34 which is formed on a straight line L which passes through a radially outer through hole 32 which lies three radially outer through holes ahead in a clockwise direction from the one radially outer through hole 32. In the plural outer surface grooves 37, however, 12 outer surface grooves 37a which extend towards the deployment portion 31a extend in an involute fashion from the corresponding radially outer through holes 32 to straight lines L which pass through the radially outer through holes 32 which lie three radially outer through holes ahead in the clockwise direction from the radially outer through holes 32 from which the outer surface grooves 37a start to extend and thereafter are

6

bent radially outwards so as to connect to the corresponding connecting terminal joining holes 39.

As shown in a front view of the base plate in FIG. 7, each inner surface groove 38 on the base plate 31 is formed in such a curved fashion as to avoid the interference with the corresponding radially outer through hole 32 so as to connect one radially inner through hole 33 with one radially outermost hole 34 which is formed on a straight line L which passes through a radially inner through hole 33 which lies three radially inner through holes ahead in a clockwise direction (in a counterclockwise direction when seen from the front side of the base plate 31L shown in FIG. 6) from the one radially inner through hole 33. In the plural inner surface grooves 38, however, 12 inner surface grooves 38a which extend towards the deployment portion 31a extend similarly in a curved fashion from the corresponding radially inner through holes 33 to straight lines L which pass through the radially inner through holes 33 which lie three radially inner through holes ahead in the clockwise direction (in the counterclockwise direction when seen from the front side of the base plate 31L shown in FIG. 6) from the radially inner through holes 33 from which the inner surface grooves 38a start to extend and thereafter are bent radially outwards so as to connect to the corresponding connecting terminal joining holes 39.

Namely, as shown in FIG. 6, the radially outer through hole 32 and the radially inner through hole 33 which are spaced six radially outer or inner through holes apart from each other in the clockwise direction (or in the counterclockwise direction) are connected to each other via the radially outermost hole 34 to which the outer surface groove 37 and the inner surface groove 38 commonly connect. In addition, the pair of outer surface groove 37a and inner surface groove 38a which connect to the common connecting terminal joining hole 39 connect the radially outer through hole 32 with the radially inner through hole 33 which are spaced six radially outer or inner through holes apart from each other in the clockwise direction (or in the counterclockwise direction).

In the base plate assembly 30R, each outer surface groove 37 on the base plate 31R has the same shape of each inner surface groove 38 on the base plate 31L, and each inner surface groove 38 on the base plate 31R has the same shape as each outer surface groove 37 on the base plate 31L.

The connection coil 40 is formed of a conductive material such as copper into the shape of a plate. The connection coils 40 are divided into outer connection coils 41 (41a, 41b) which are inserted in the outer surface grooves 37, 37a and inner connection coils 42 (42a, 42b) which are inserted in the inner surface grooves 38, 38a. When referred to herein, the outer connection coils 41 are the connection coils 40 which are disposed on an axially outer side of the stator 10 when the stator core assembly 20 and the base plate assemblies 30 are assembled together, and the inner connection coils 42 are the connection coils 40 which are disposed on an axially inner side of the stator 10.

As shown in FIG. 6, the outer connection coils 41a are formed along the involute curves having the same shape of the outer surface grooves 37, and connection holes 43a, 43b are formed at both end portions of the outer connection coils 41a. The connection hole 43a has a diameter which is substantially the same as that of the small-diameter portion 26a of the radially outer coil bar 26, and the connection hole 43b has a diameter which is substantially the same as that of a connecting pin 45, which will be described later, for connecting together the outer connection coil 41a and the inner connection coil 42a. In addition, the outer connection coils 41b are formed in a curved fashion to have the same shape as that of the outer surface grooves 37a, and connection holes 43a and

7

connecting terminal holes **43c** are formed at both end portions of the outer connection coils **41b**.

As shown in FIG. 7, the inner connection coils **42a** are formed along the involute curves having the same shape of the inner surface grooves **38**, and connection holes **44a**, **44b** are formed at both end portions of the inner connection coils **42a**. The connection hole **44a** has a diameter which is substantially the same as that of the small-diameter portion **27a** of the radially inner coil bar **27**, and the connection hole **44b** has a diameter which is substantially the same as that of the connecting pin **45**. In addition, the inner connection coils **42b** are formed in a curved fashion to have the same shape as that of the inner surface grooves **38a**, and connection holes **44a** and connecting terminal holes **44c** are formed at both end portions of the inner connection coils **42b**.

Consequently, except for the portion of the base plate **31L** where the connecting terminal joining holes **39**, the inner connection coils **42a** and the outer connection coils **41a**, **41b** that are all connected to the radially outer coil bars **26** are formed along the involute curves, and the inner connection coils **42a**, **42b** and the outer connection coils **41a** that are all connected to the radially inner coil bars **27** are formed along the involute curves so as to extend radially outwards from the radially inner through holes **33** on a radially inner side of the involute curves with bypassing the radially outer through hole **32**.

The outer connection coils **41a**, **41b** are inserted in the outer surface grooves **37**, **37a**, respectively, and the inner connection coils **42a**, **42b** are inserted in the inner surface grooves **38**, **38a**, respectively. The conductive connecting pins **45** which are made of copper or aluminum are inserted in the radially outermost holes **34** so as to electrically connect the outer connection coils **41a** and the inner connection coils **42a**.

By so doing, the base plate assemblies **30L**, **30R** are built up in such a state that the connection holes **43a** of the outer connection coils **41a** and the connection holes **44a** of the inner connection **42a** which are disposed six connection holes apart from each other in the clockwise direction (or in the counterclockwise direction) are electrically connected via the outer connection coils **41a**, the connecting pins **45** and the inner connection coils **42a**.

In place of providing the connecting pins **45** as in this embodiment, a configuration may be adopted in which projecting portions having the same shape of the connecting pin **45** are formed integrally on either of the outer connection coils **41a** and the inner connection coils **42a**, so that the projecting portions so formed are inserted in connection holes **43b**, **44b** which are provided on the other of the outer connection coils **41a** and the inner connection coils **42a**, whereby the outer connection coils **41a** and the inner connection coils **42a** are electrically connected to each other.

The pair of base plate assemblies **30L**, **30R**, which are configured as has been described heretofore, are disposed in the predetermined positions on both the ends of the stator core assembly **20** so as to be assembled thereto. As shown in FIG. 5, in the base plate assembly **30L** which is disposed at the one end face **21a** (the left end face in the figure) of the stator core **21**, the small-diameter portions **26a** of the radially outer coil bars **26** are inserted in the connection holes **43a** of the outer connection coils **41a**, **41b**, and the small-diameter portions **27a** of the radially inner coil bars **27** are inserted in the connection holes **44a** of the inner connection coils **42a**, **42b**. Thereafter, the small-diameter portions **26a**, **27a** are crimped to be fixed in place in the corresponding connection holes **43a**, **44a**. Namely, the outer connection coils **41a**, **41b** and the inner connection coils **42a**, **42b** connect together the coil bars

8

25 of the same phase (for example, a U-phase) to thereby form extending portions of a coil **50**.

In the base plate assembly **30R** which is disposed at the other end face **21b** (the right end face in the figure) of the stator core **21**, the small-diameter portions **26a** of the radially outer coil bars **26** are inserted in the connection holes **44a** of the inner connection coils **42a**, and the small-diameter portions **27a** of the radially inner coil bars **27** are inserted in the connection holes **43a** of the outer connection coils **41a**. Thereafter, the small-diameter portions **26a**, **27a** are crimped to be fixed in place in the corresponding connection holes **43a**, **44a**. Namely, the outer connection coils **41a** and the inner connection coils **42a** connect together the coil bars **25** of the same phase (for example, the U-phase) to thereby form extending portions of the coil **50**.

Consequently, with respect to the radially outer coil bar **26** and the radially inner coil bar **27** which are disposed in the same slot **23**, the outer connection coil **41a** which is connected to the one end (the left end in the figure) of the radially outer coil bar **26** extends radially outwards and in the clockwise direction to connect to the inner connection coil **42a** of the same phase, while the inner connection coil **42a** which is connected to the other end (the right end in the figure) of the radially outer coil bar **26** extends radially outwards and in the counterclockwise direction to connect to the outer connection coil **41a** of the same phase. In addition, the inner connection coil **42a** which is connected to the one end (the left end in the figure) of the radially inner coil bar **27** extends radially outwards and in the counterclockwise direction to connect to the outer connection coil **41a** of the same phase, while the outer connection coil **41a** which is connected to the other end (the right end in the figure) extends radially outwards and in the clockwise direction to connect to the inner connection coil **42a** of the same phase.

In this way, the stator **10** is made up by assembling the pair of base plate assemblies **30L**, **30R** to both the ends of the stator core assembly **20**, whereby segmented coils **50** make up four coil loops for each phase which has the same construction (U-phase coils **50U**, V-phase coils **50V**, and W-phase coils **50W**). In these four coil loops of the three phases (the U-phase coils **50U**, the V-phase coils **50V**, and the W-phase coils **50W**), two coil loops make up a set, and hence, two sets of U-phase coils **50U**, two sets of V-phase coils **50V**, and two sets of W-phase coils **50W** are wave wound in the counterclockwise direction in this order (refer to FIGS. 8 and 10). Then, the radially outer coil bar **26** and the radially inner coil bar **27** which are covered together by the insulation material **28** to be disposed within the same slot **23** each include two coil loops which make up one set. FIG. 8 is a perspective view of double-slot type, segmented coils of plural phases (U-, V- and W-phase) which are taken out from the stator for better understanding, and FIG. 9 is a perspective view of coils of one phase (for example, U-phase) which are taken out, in turn, from the coils of the plural phases. FIG. 10 is an exemplary diagram showing the configuration of the coils of the plural phases, and in FIG. 11A is a partial enlarged view of FIG. 6, and FIG. 11B is a sectional view taken along the line B-B in FIG. 11A.

Additionally, in the stator **10** which is configured in the way described heretofore, the outer connection coils **41a**, **41b** and the inner connection coils **42a**, **42b** are disposed within a region where the stator core **21** is projected in the axial direction and are disposed in different positions with respect to the axial direction.

In the sectional view of the base plate assembly **30L** taken along the line B-B which is shown in FIG. 11A, as shown in FIG. 11B, on the outer surface of the base plate **31L**, two

V-phase outer connection coils **41b** and one W-phase outer connection coil **41b** are aligned in this order from in a radially inward to outward direction at the small-diameter portion **26a** of the U-phase radially outer coil bar **26** from a radially inner side, while on the inner surface of the base plate **31L**, one U-phase connection coil **42b** and two W-phase inner connection coils **42b** are aligned in this order from the radially inner. Consequently, as is clear from FIG. 11A, the inner connection coils **42a**, **42b** face the outer connection coils **41a**, **41b** of the different phase in the axial direction, and the outer connection coils **41a**, **41b** face the inner connection coils **42a**, **42b** of the different phase in the axial direction.

In addition, outer surfaces of the plural outer connection coils **41a**, **41b** which are disposed at the axially outer ends of the stator **10** are level with the end faces of the base plates **31L**, **31R**.

Additionally, as is shown in FIG. 5, the coils **50** are assembled to the stator **10** so that the outer connection coils **41a**, **41b** which connect to the radially outer coil bars **26** are situated axially outwards at the one end face **21a** of the stator core **21**, while at the other end face **21b** of the stator core **21**, the outer connection coils **41a** which connect to the radially inner coil bars **27** are situated axially outwards.

FIGS. 12A to 12C show conceptual diagrams showing connecting constructions between a coil bar and connection coils. Hereinafter, the radially outward coil bar **26** is taken as an example for description. However, connecting constructions which will be described below can also be applied to the radially inner coil bar **27**. In a radially outer coil bar **26** shown at FIG. 12A, tapered portions **26b** which are tapered towards ends of the radially outer coil bar **26** are formed at both end portions, and a connection hole **43a** in an outer connection coil **41a** or **41b** and a connection hole **44a** in an inner connection coil **42a** are made into a tapered hole having a gradient which is substantially equal to that of the end portions of the radially outer coil bar **26**. The radially outer coil bar **26** and the connection coils **40** are assembled together so that the base plates **31L**, **31R** are assembled to the stator core **21** and the connection coils **40** are then pressed axially relative to the radially outer coil bar **26** by pressing members **61** of jigs by virtue of elastic forces of springs **69**, whereby the connection holes **43a**, **44a** of the connection coils **40** are fitted on the tapered portions **26b** of the radially outer coil bar **26**. Then, the end portions of the radially outer coil bar **26** are crimped by being crushed to be deformed at ends by a punch **62**, whereby the coil bar **26** and the connection coils **40** are fixed together.

As this occurs, the fitting portions between the radially outer coil bar **26** and the connection coils **40** are tapered, and therefore, even in case centers of the radially outer coil bar **26** and the connection coils **40** are offset slightly, the radially outer coil bar **26** and the connection coils **40** are centered by virtue of pressures applied thereto by the pressing members **61** so that the radially outer coil bar **26** and the connection coils **40** are joined together at the tapered portions **26b** in an ensured fashion to thereby establish an electric communication therebetween. In addition, such joining can be executed at plural locations (96 locations in this embodiment) through a single pressing operation. Thus, the joining work can be executed efficiently, thereby making it possible to increase the fabrication efficiency remarkably. It should be noted that the coil bar **25** and the connection coils **40** do not necessarily have to be connected together by press fitting and crimping, and hence, they may be connected together by press fitting or crimping. Thus, a connection of the coil bar **25** and the connection coils **40** based on press fitting will be described below.

End portions of a radially outer coil bar **26** shown in FIG. 12B are formed into a semi-spherical shape, and connection holes **43a**, **44a** of connection coils **40** are formed into a semi-spherical depressed portion. In this construction, the semi-spherical end portions of the radially outer coil bar **26** are press fitted in the connection holes **43a**, **44a** of the connection coils **40**, whereby the radially outer coil bar **26** and the connection coils **40** are joined together. In this construction, too, the radially outer coil **26** and the connection coils **40** can be centered. In addition, such joining can be executed at plural locations through a single pressing operation, whereby the radially outer coil **26** and the connection coils **40** can be joined together extremely efficiently.

A radially outer coil bar **26** shown in FIG. 12C is formed to have a rectangular cross section, and end portions thereof are formed into a semicircular shape. In addition, connection holes **43a**, **44a** of connection coils **40** are similarly formed into a semicircular depressed portion, and the radially outer coil bar **26** and the connection coils **40** are joined together by press fitting the end portions of the radially outer coil **26** into the connection holes **43a**, **44a** which are the semicircular depressed portions. Being given the rectangular cross section, the radially outer coil bar **26** of this embodiment has an angular shape which closely matches that of the slot **23**, and therefore, the space factor of the slot **23** can also be enhanced.

FIG. 13 is a perspective view of the stator in which cooling plates are disposed at end faces of the base plate assemblies, and FIG. 14 is a vertical sectional view of a main part of the stator. As shown in FIGS. 13 and 14, a pair of cooling plates **60** are disposed so as to be in contact with the base plate assemblies **30** which are provided at both the end faces of the stator **10**. A refrigerant passageway **63** is formed in an interior of the cooling plate **60** so that a refrigerant is allowed to circulate therein. Then, a refrigerant which is sent under pressure from a refrigerant supply system, not shown, is circulated in, for example, a direction indicated by an arrow C (refer to FIG. 13) in the refrigerant passageway **63** in the cooling plate **60**. Thus, the stator **10** can be cooled positively via the outer connection coils **41a**, **41b** (the extending portions) of the stator **10** with which the pair of cooling plates **60** are in contact.

Additionally, side surfaces of the outer connection coils **41a**, **41b** are flat, and therefore, the outer connection coils **41a**, **41b** are brought into surface contact with the cooling plates **60**. Because of this, compared with a conventional coil around which a winding is wound, the contact area with the cooling plates **60**, that is, the heat conduction area is large, thereby making it possible to cool the stator **10** efficiently.

Additionally, in the coils **50**, at the one end face **21a** of the stator core **21**, the outer connection coils **41a**, **41b** which connect to the radially outer coil bars **26** are situated axially outwards, while at the other end face **21b** of the stator core **21**, the outer connection coils **41a** which connect to the radially inner coil bars **27** are situated axially outwards. Therefore, the radially outer coil bars **26** and the radially inner coil bars **27** are cooled uniformly via the outer connection coils **41a**, **41b** to thereby suppress the heat distribution of the coils. Further, the coils **50** are free from concerns caused when an oil cooling process using an ATF oil or the like is selected that the coils and the insulation materials are badly affected by the ATF oil which is sprayed to the coils, the reliability and durability of the stator being thereby enhanced.

Thus, as has been described heretofore, the stator **10** according to the embodiment includes the stator core **21** and the segmented coils **50** of plural phases, and the segmented coils **50** of plural phases have the plural coil bars **25** which are inserted individually in the plural slots **23** in the stator core **21**.

11

and which extend substantially in the straight line and the plural connection coils **40** which connect together the coil bars **25** of the same phase to thereby make up the extending portions. The coil bars **25** are fixed in place individually in the slots **23** in the stator core **21** in such a state that the coil bars **25** each are covered by the insulation material **28**. Therefore, the stator core **21**, the coil bars **25** and the insulation materials **28** are unitized, whereby not only are the handling properties enhanced, but also the insulation performance is enhanced. In addition, the coils **50** of plural phases can easily be fabricated by inserting the coil bars **25** each covered by the insulation material **26** individually in the slots **23** in the stator **21**.

In addition, the coil bars **25** of the same phase are inserted individually in the slots **23** in the stator core **21** while being combined together by the insulation material **28** so as to become a whole, and therefore, the handling properties are improved, and the plural coil bars **25** as a whole can easily be inserted in the slot **23**.

Additionally, the coil bars **25** which are inserted together in the slot **23** have the same length and are configured as the radially outer coil bar **26** and the radially inner coil bar **27** which are aligned in the radial direction, and the radially outer coil bar **26** and the radially inner coil bar **27** are covered by the insulation material **28** in such a state that the radially outer and inner coil bars are offset from each other in the axial direction so that the end portions thereof take the different axial positions. Therefore, parts for the radially outer coil bar **26** and the radially inner coil bar **27** can be commonized.

In addition, the radially outer coil bar **26** and the radially inner coil bar **27** which are covered together by the insulation material **28** are press fitted in the slot **23** in the stator core **21**, and therefore, the radially outer coil bar **26** and the radially inner coil bar **27** can be fixed in place in the slot **23** in the stator core **21** easily and in an ensured fashion.

It should be noted that the invention is not limited to the embodiment that has been described heretofore and hence can be modified or improved as required.

For example, in the embodiment, 12 connecting terminal joining holes **39** are formed. However, the invention is not limited thereto, and hence, a configuration may be adopted in which six connecting terminal joining holes **39** are formed, and adjacent connection coils of the same phase are connected together.

Additionally, an insulation cover may be disposed at the axially outer ends of the pair of base plate assemblies **30L**, **30R**. Alternatively, the axially outer ends may be covered with a resin or the like.

The stator **10** of the invention is not limited to the double-slot type stator that has been described above. For example, the stator **10** can be configured as a single-slot type stator of which the shape of coils of one phase is shown in FIG. **15** or can be configured as a triple-slot type stator of which the shape of coils of one phase is shown in FIG. **16**. In a three-phase, eight-pole, wave wound stator, in the case of the single-slot type stator, the number of slots in the stator core **21** is 24, and in the case of the triple-slot type stator, the number of slots in the stator core **21** is 72. The stator of either type has

12

the same construction as that of the double-slot type stator **10**, and hence, the description thereof will be omitted here.

What is claimed is:

1. A stator for an electric rotary machine comprising:

a stator core having a plurality of slots;
segmented coils of a plurality of phases; and
insulation material, wherein:

the segmented coils of a plurality of phases have pluralities of coil bars which are inserted individually in the plurality of slots in the stator core and which extend substantially in a straight line and pluralities of connection coils which connect together the coil bars of the same phase to thereby make up extending portions;

the coil bars are fixed in place individually in the slots in the stator core;

the coil bars which are inserted in the slots are each configured as having a radially outer coil bar and a radially inner coil bar aligned in the radial direction, wherein the radially outer coil bar and the radially inner coil bar are independently separated from each other;

the insulation material comprising the radially outer coil bar and the radially inner coil bar, wherein the radially outer coil bar and the radially inner coil bar are integrally covered by the insulation material, the insulation material is interposed between the radially outer coil bar and the radially inner coil bar, and an end portion of the radially outer coil bar and an end portion of the radially inner coil bar take different axial positions; and

the radially outer coil bar and the radially inner coil bar are fixed integrally by the insulation material in such a state that the end portion of the radially outer coil bar and the end portion of the radially inner coil bar take different axial positions at both ends of the stator core.

2. The stator core for an electric rotary machine according to claim 1, wherein

the coil bars of the same phase are inserted in the slot.

3. The stator core for an electric rotary machine according to claim 1, wherein:

the coil bars which are inserted together in the slot have the same length.

4. The stator core for an electric rotary machine according to claim 3, wherein

the radially outer coil bar and the radially inner coil bar are press fitted in the slot in the stator core.

5. The stator core for an electric rotary machine according to claim 1, wherein

the radially outer coil bar and the radially inner coil bar are disposed parallel to each other while being offset from each other in the axial direction in the amount of a thickness of the connection coil.

6. The stator core for an electric rotary machine according to claim 1, wherein the end portion of the radially outer coil bar and the end portion of the radially inner coil bar that take different axial positions are connected by the connection coil, the radially outer coil bar and the radially inner coil bar being arranged in different slots.

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